

# Work Order ID 76846

November-22-11 9:59:40 AM

**\*76846\***

Page 1

Item ID: D350-578-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bearpaw

Stop **\*NS2\***

Start Date: 22/11/2011 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 11/11/22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-578-011 CHG005								

11/11/29 (3)  
ML5 11-11-29

160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									

11/11/29 (3)

170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

11/11/29 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 06/12/2011 Req'd Qty: 8.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: _____								
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

11/11/29 (3)

11/11/29

mf 11-11-29

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

November-22-11 9:59:45 AM

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Work Order ID: 76846

**\*76846\***

Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A

Purchased

No

160

Each

604.0000

12

96

\*\*

**\*AN4-17A\***

Bolt

Location

Loc Qty

Loc Code

ST358

4

116419

0

116704

0

117619

4

ST359

600

118628

300

118983

300

D2182B

Manufactured

No

160

f

725.2542

2.5

20

\*\*

**\*D2182B\***

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

725.25417

66063

59.94817

73932

665.306

Cut qty 6 at 5.00" long

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*76846\***

Parent Item: D350-578-011

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Parent Item Name: Bearpaw

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 8.00

Required Qty: 8.00

*n/h*  
*x3*  
D2274  
**\*D2274\***  
Radius Block

Manufactured No 160 Each 463.0000 12 96

\*\*

*S*

Location	Loc Qty	Loc Code
ST010	250	
72121	16	
73389	234	
ST139	213	
74435	213	

*n/h*  
*x3*  
D2432  
**\*D2432\***  
206 (24") Bearpaw

Manufactured No 160 Each 1.0000 2 16

\*\*

*B73981*

Location	Loc Qty	Loc Code
ST495	1	
68672	0	
69653	1	

*n/h*  
*x3*  
D2438  
**\*D2438\***  
Clamp

Manufactured No 160 Each 229.0000 6 48

\*\*

*S*

Location	Loc Qty	Loc Code
ST456	229	
69737	84	
73400	145	

*n/h*  
*x3*  
D2529  
**\*D2529\***  
Washer

Manufactured No 160 Each 793.0000 12 96

\*\*

*11/11/29*

Location	Loc Qty	Loc Code
ST016	793	
71161	250	
73486	43	
76086	500	

*Bb*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Parent Item: D350-578-011

**\*D350-578-011\***

Parent Item Name: Bearpaw

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 8.00

Required Qty: 8.00

MS21042L4

Purchased

No

160

Each

11,294.00

12

96

**\*MS21042L 4\***

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

552

117441

51

117601

368

118451

133

ST516

5742

119017

5742

ST518

5000

119075

5000

NAS1149D0463J

Purchased

No

160

Each

12,258.00

24

192

**\*NAS1149D0463.J\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

11934

119075

10000

119097

1934

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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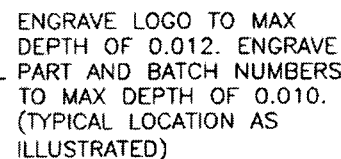
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98-06-17 KE



DEOS	EFFECTIVE
	9143
	22



0.260 (TYP)   
~~0.75 C-BORE~~ ~~0.93 C-BORE~~  
~~0.35 DEEP FROM TOP (MIN.)~~  
 0.30 DEEP FROM BOTTOM  
~~(LEAVE 0.300 MIN.)~~  
 (LEAVE 0.650 MIN.)   
 0.375 

23.750-  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 7689614.

BEND AFTER MACHINING  
(D2432B ONLY)

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

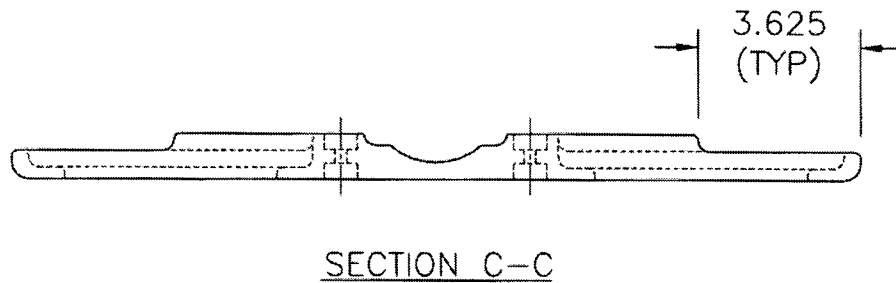
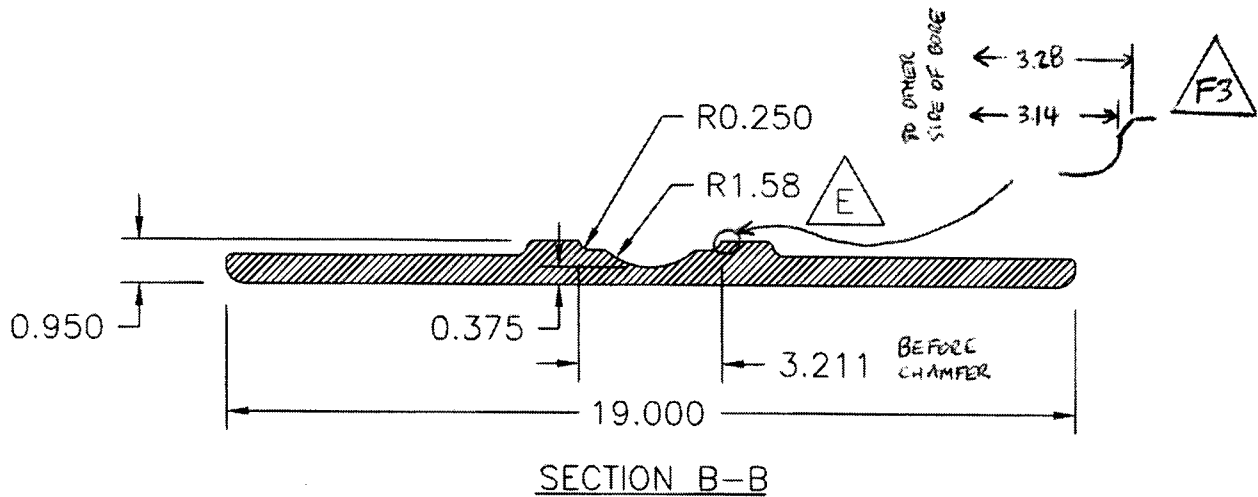
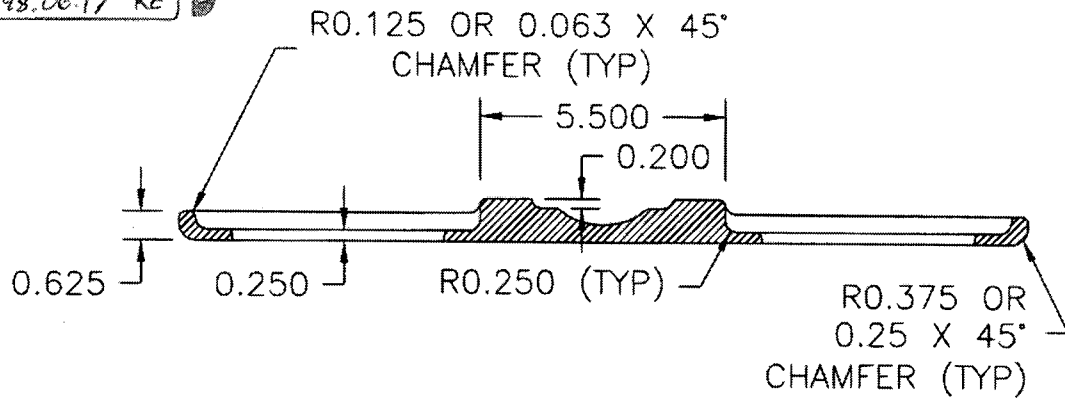
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



71084p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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